

Work Order ID 79208

79208

Page 1

January-23-12 2:00:37 PM

Item ID: D2662-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH In 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan: NLS Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00 B.A 12/02/12 10 0
 HAAS CNC vertical machine #1
 Program part number and batch number.
 Inspect part number and batch number are programmed
 MACHINE AS PER FOLIO FB069 & DWG
 DWG REV: E
 FOLIO REV: AA

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00 B.A 12/02/12 10 0
 Conventional Milling Machine
 Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Item ID: D2662-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH In 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:50	OVEN TEMPERATURE:							
	FINISH TIME: 4:20								
	3200F								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 437	0.00							
170									
Packaging	Memo	0.00							
Packaging									

10X P M L 12/02/16

10 B 122-17

C14418 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79208***79208***

Page 4

January-23-12 2:00:37 PM

Item ID: D2662-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, RH In 206

Start Date: 23/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

 M.C.J. 12/02/17MF
12-02-17

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NOTE: Date & initial all entries

Picklist Print

January-23-12 2:00:41 PM

Page 1

Work Order ID: 79208

79208

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house

processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	14.0000	1	10			

D6101-001

Saddle Billet

**

15.0 12/02/12

Location

Loc Qty

Loc Code

MAT040

14

69677

2

73774

11

76836

1

→ 78158

10.0

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	79208
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.127	0.127	0.127	0.127	0.127
G	0.210	0.230		0.227	0.227	0.227	0.227	0.227
H	0.615	0.685		0.685	0.685	0.685	0.685	0.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.330	1.330	1.330	1.330	1.330
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
L	0.470	0.530		0.500	0.500	0.500	0.500	0.500
M	1.125	1.145		1.1385	1.1385	1.1385	1.138	1.1385
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145		0.138	0.138	0.138	0.138	0.138
P	0.240	0.260		0.255	0.255	0.255	0.255	0.255
Q	0.677	0.697		0.687	0.687	0.687	0.687	0.687
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.922	0.922	0.922	0.922	0.922
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.499	0.499	0.499	0.499	0.499
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.118	0.118	0.118	0.118	0.117
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AH								
AI								

W/O:		WORK ORDER CHANGES					
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Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: B.A.	Date: 12/02/12
Audited by: [Signature]	Date: 12/02/14
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
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Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#6	#7	#8	#9	#10
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		0.127	0.127	0.127	0.127	0.127
G	0.210	0.230		0.227	0.227	0.227	0.227	0.227
H	0.615	0.685		0.685	0.685	0.685	0.685	0.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.330	1.330	1.330	1.330	1.330
K	0.178	0.198		0.188	0.188	0.188	0.188	0.188
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M	1.125	1.145		1.1385	1.1385	1.1385	1.1385	1.138
N	0.100	0.180		0.135	0.135	0.135	0.135	0.135
O	0.100	0.145		0.137	0.138	0.138	0.138	0.137
P	0.240	0.260		0.255	0.255	0.255	0.255	0.255
Q	0.677	0.697		0.687	0.687	0.687	0.687	0.687
R	0.540	0.560		0.550	0.550	0.550	0.550	0.550
S	0.912	0.932		0.922	0.922	0.922	0.922	0.922
T	0.787	0.807		0.797	0.797	0.797	0.797	0.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		0.498	0.499	0.499	0.499	0.498
X	0.312	0.319		0.314	0.314	0.314	0.314	0.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		0.118	0.118	0.117	0.118	0.118
AE	0.235	0.240		0.237	0.237	0.237	0.237	0.237
AF	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AG	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AH								
AI								

DART AEROSPACE LTD		Work Order:	79200
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

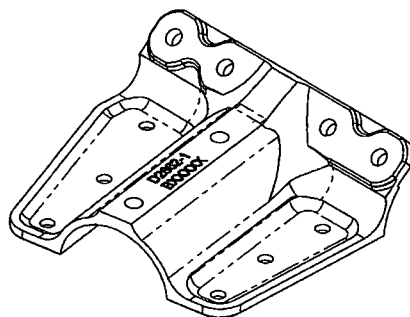
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: B.A. **Date:** 12/02/13

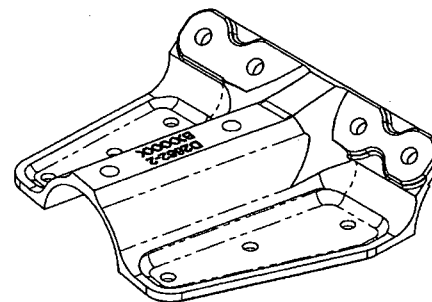
Audited by: *[Signature]* **Date:** 12/02/14

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16

SEAL
REFUSED
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT

WITHOUT A
WORK ORDER
NO. 79208 M.C.J.
12/01/23

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2, B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D2662	REV. E SHEET 1 OF 5
TITLE SADDLE, INSIDE	SCALE NTS
<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS SUPPLIED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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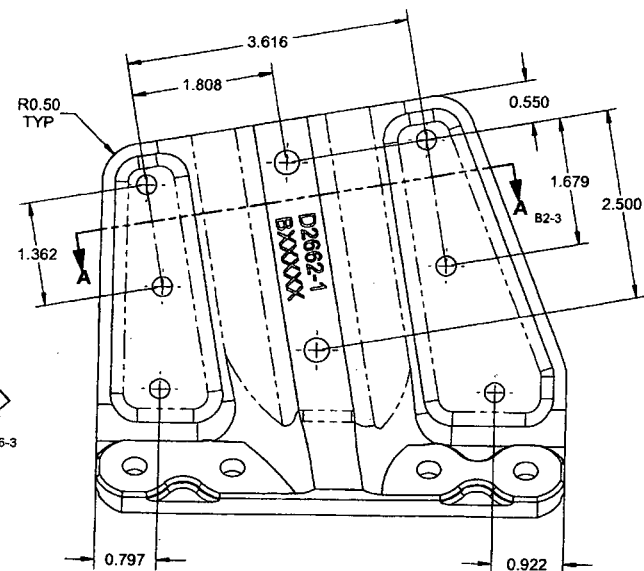
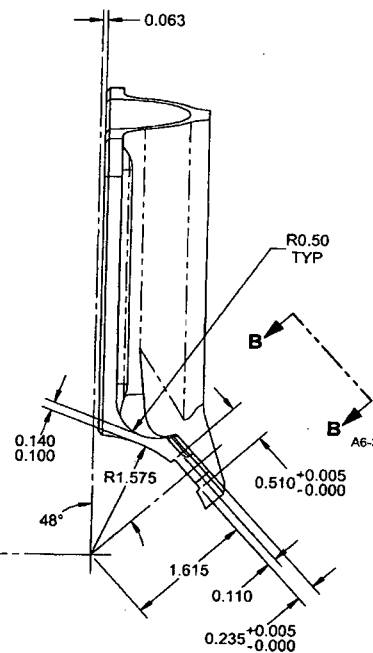
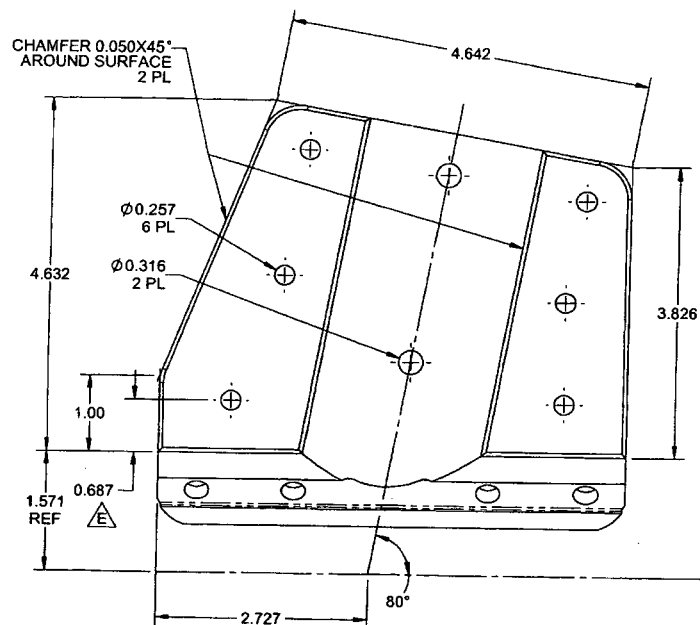
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

79208



RELEASE
2011-11-16

D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	90	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	90		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	2/11/10	D2662	SHEET 2 OF 5
APPROVED	2/11/10	TITLE	SCALE
DE APPR.	2/11/10	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PREPARED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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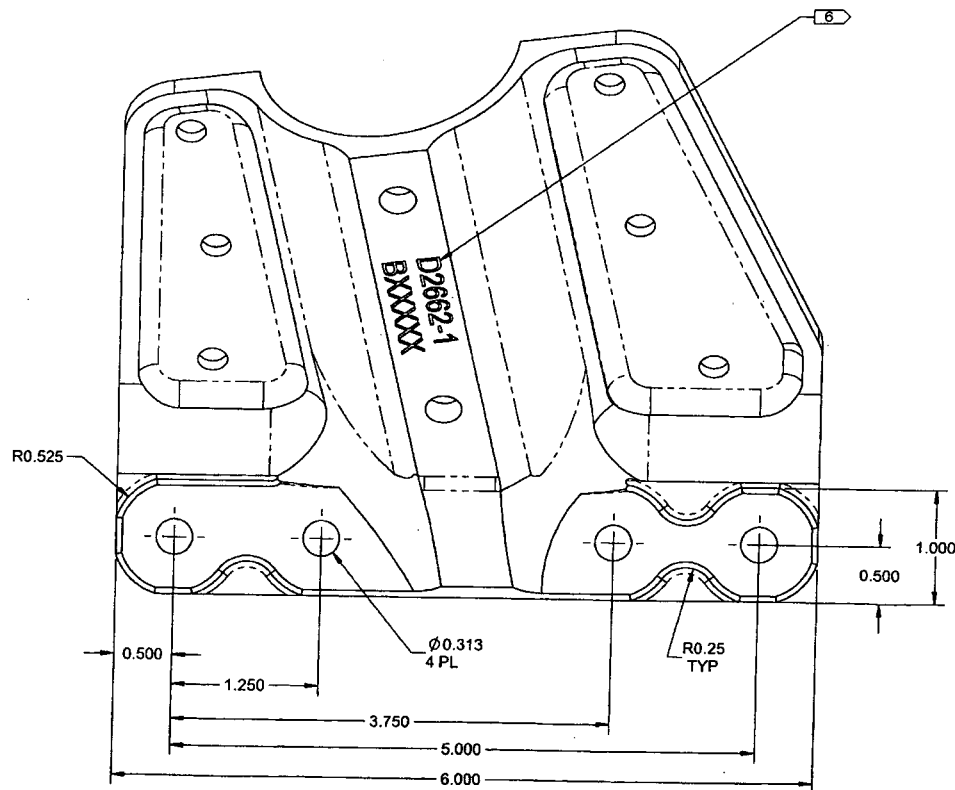
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

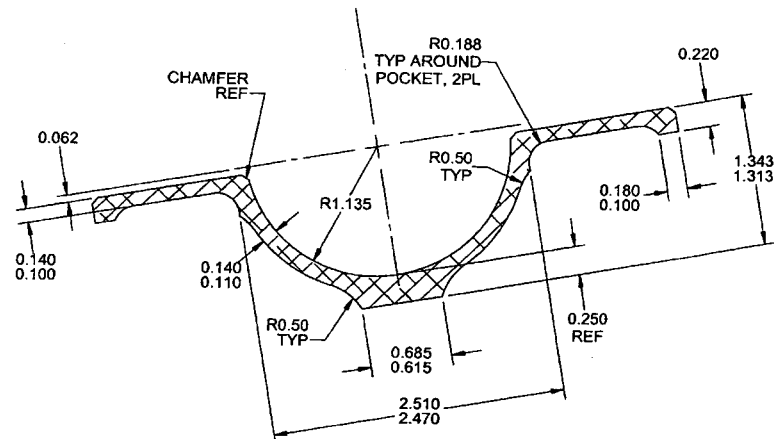
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NOTE: Date & initial all entries

79208



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C1-2

RELEASED
2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	135	DRAWING NO.	REV. E
MFG. APPR.	135	D2662	SHEET 3 OF 5
APPROVED	135	TITLE	SCALE
DE APPR.	135	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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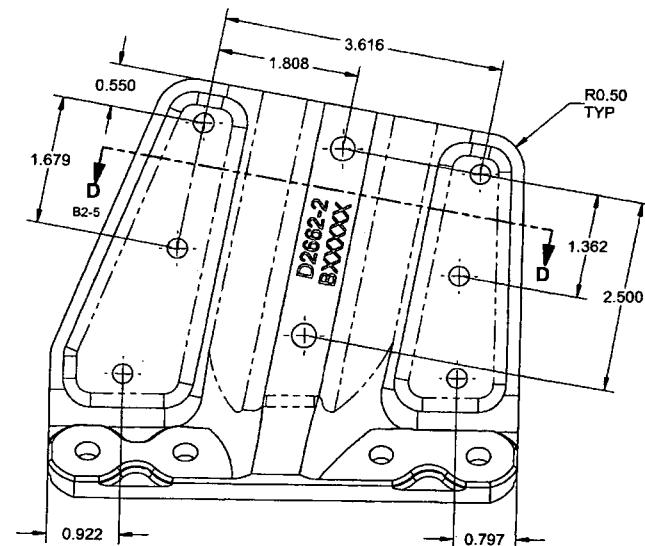
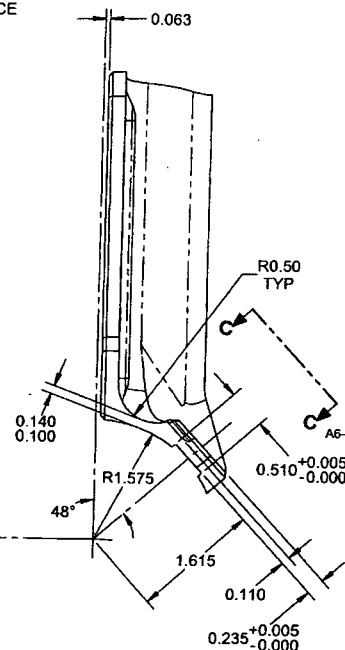
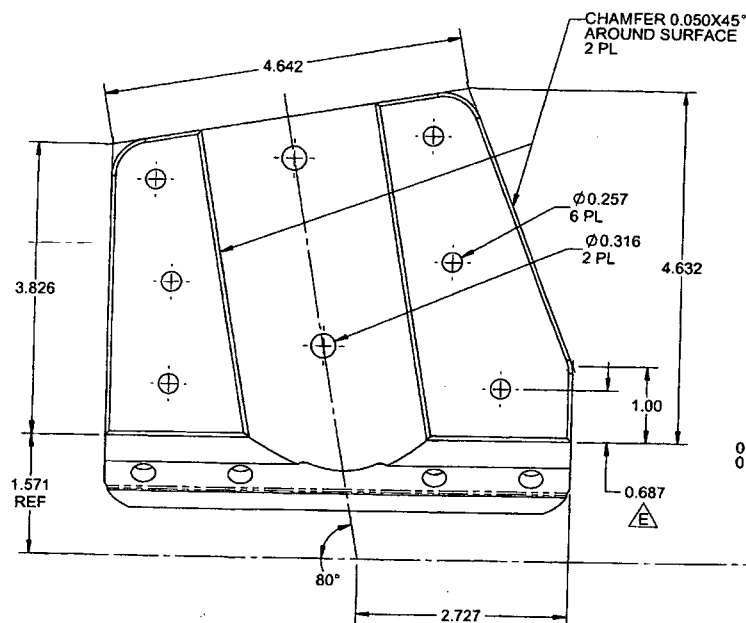
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79208



RELEASED
2011-11-16

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a mechanical part, likely a bracket or support, showing a side view with dimensions and features.

Key features and dimensions:

- Part Label:** D2662-2 BXXXXX
- Dimensions:**
 - Overall width: 6.000
 - Overall height: 1.000
 - Base thickness: 0.500
 - Top flange thickness: 0.500
 - Distance from left edge to first hole center: 0.500
 - Distance between first and second hole centers: 1.250
 - Distance from left edge to third hole center: 3.750
 - Distance from left edge to fourth hole center: 5.000
- Features:**
 - Four circular holes in the base, each with a diameter of $\varnothing 0.313$ and a length of 4 PL.
 - Two circular holes in the top flange.
 - Radius R0.525 TYP on the top flange corners.
 - Radius R0.25 TYP on the base corners.

Technical drawing of a mechanical part showing dimensions and tolerances. The drawing includes the following features and dimensions:

- Top Left:** Dimensions 0.063 and 0.140 0.100.
- Top Center:** CHAMFER REF.
- Top Right:** R0.188 TYP AROUND POCKET, 2PL.
- Left Side:** Dimensions 0.140 0.100 and R1.135.
- Bottom Left:** R0.50 TYP.
- Bottom Center:** Dimensions 0.685 0.615 and 2.510 2.470.
- Bottom Right:** 0.250 REF.
- Right Side:** Dimensions 0.180 0.100, 0.220, 1.34, and 1.31.

RELEASE
2011-11-16

DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONCOITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	<i>g</i>		SHEET 5 OF 5
CHECKED	<i>JS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries